

Date: Tuesday, 3/11/2008 9:58:22 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	NUT PLATE ASSEMBLY		
Job Number	37769			Part Number	D2873043		
Estimate Number	11053			Drawing Number	D2873 REVA		
P.O. Number				Project Number	N/A		
This Issue	3/11/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/25/2008	Qty:	30
Previous Run	37340			Um:	Each		
Written By	<i>JL</i> 08 03 11						
Checked & Approved By							
Comment	Est	A	05.09.13	New issue	KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR	
		Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s) 6061T6 BAR Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000)	<i>M107220 - 2 Blanks</i>
		Identify for D2873-3 Batch: M107244	<i>SA</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 1.000" x 0.375" x 3.700" long	<i>SA 08/03/15</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev <u>A</u> Folio Rev <u>A</u>	<i>HAAS</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>HAAS 08/03/17</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 9:58:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 37769

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/03/19

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C-sink as per Dwg D2873

ml 08/03/04 x 30

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SK 08-03-25

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



x30

Comment: INSPECT CHEMICAL CONVERSION

ml 08/03/27

10.0 MS20426AD46 Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet

Pick;

Qty	Part Number	Description	Batch
6	MS20426AD4-6	Rivet	M103395

Description

Batch

M103395

R

11.0 MS21075L5 Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Nut Plate

Pick;

Qty	Part Number	Description	Batch
3	MS21075L5	Nut Plate	18136

Description

Batch

18136

8/3/04 (30)

W/I/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 9:58:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 37769

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

X27

ml 08/03/27

PTO

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (X27)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 10n 008

LC 03/31 (27)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

W

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-03-31

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-043 PAR #: N/A Fault Category: Prod/Fab. Ass. red & small NCR: No DQA: Date: 08/04/04
 QA: N/C Closed: Date: 08/04/04

NCR: 37769		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/04	12	Tried to Squeeze rivets with tool, Some of Nut plate was lock. Scrap 3x D2873-3 Radial Block Scrap: 29 nut plates and 58 rivets	Initial 10/04/04	J.L. made a new tool to fit. Replace 29 Nut plate M18136 58 rivets M105144 No replace D2873-3	MJL 08/03/04	✓ 10/05/04	✓ 10/05/04	✓ 10/05/04
				✓ 10/05/04				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37769
Description: Radius Block	Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A.</u>	Audited by:	<u>SJ</u>	Prototype Approval:	N/A
Date:	08/03/17	Date:	08/03/19	Date:	N/A

<u>Rev</u>	<u>Date</u>	<u>Change</u>	<u>Revised by</u>	<u>Approved</u>
A	06.08.30	New Issue	P/O D2873-043	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



